

**Work Order ID 64122**

Wednesday, November 24, 2010 3:56:23 PM



Page 1

Item ID: D3897-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-11-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

Draw Nbr

Revision Nbr

100



Waterjet

FLOW CNC Waterjet

6061-050

Memo

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



QC2- Inspect parts off machine FAI/FAIB

0.00

10-11-29

QC

Quality Control

Memo

0.00

10-11-29

W/O: 604122

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Perm. Change -update lesson box to have clear the correct information. Duy 3897 Rev B		10.12.01			lu/30

Part No: D3897-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
~	~	~			~			~

NOTE: Date &amp; initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Set Up/  
Run Hours

0.00

S101130

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

Memo

0.00

N/A S

Small Fab

1- Deburr if necessary

140



Brake NC

Memo

0.00

S101130

Brake NC

1- Bend as per dwg

0.00

(5)

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Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

150



QC

Quality Control

Operation  
Description

QC5- Inspect part completeness to step on W/O

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

8/24/13

(43)

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

10/11/13

S Q

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

5 Blk 10-11-13

**Work Order ID 64122**

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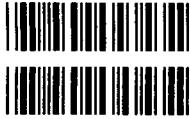
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Item ID: D3897-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 11/24/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

180

Operation  
DescriptionIdentify as per dwg & Stock Location: 92Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Packaging

Packaging

Memo

0.00

11/30

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/10 1011/30 5

# Picklist Print

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Page 1

Work Order ID: 64122



Parent Item: D3897-1



Parent Item Name: Angle

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	199.5900	0.25	1.052632	1.3		

6061-T6 .050 Sheet



Location	Loc Qty	Loc Code
MAT	166.8	
114799	38.8	
114993	128	
MAT21	32.79	
110791	1.2	110791
113216	31.59	

(5)

DART AEROSPACE LTD	Work Order:	64122
Description: Angle	Part Number:	D3897-1
Inspection Dwg: D3897	Rev: B	Page 1 of 1

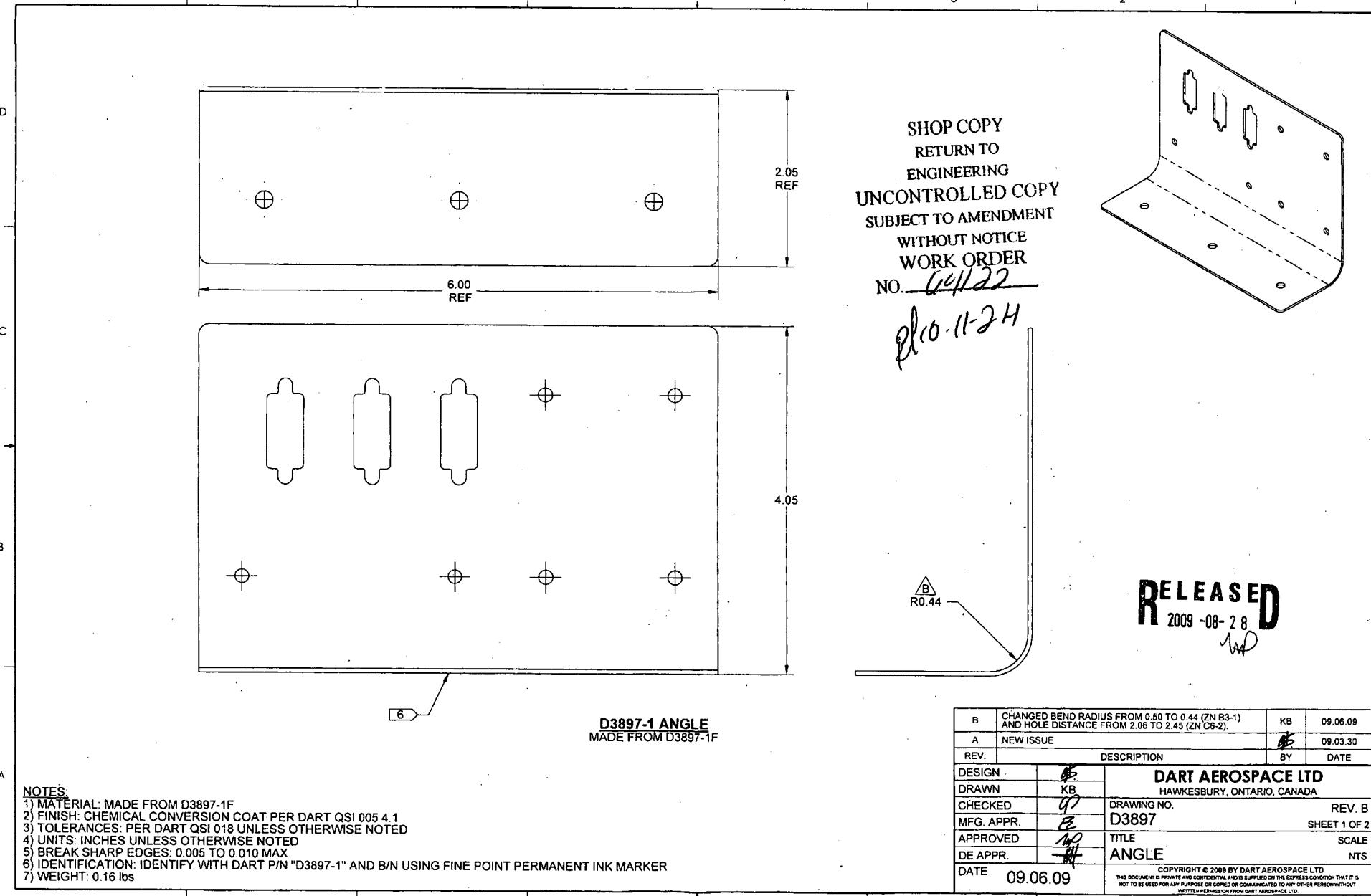
# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>BS</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>10-11-29</u>	Date: <u>10/14/30</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.11.04	New Issue	KJ	

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

